

Work Order ID 53865

November 20, 2009 12:53:41 PM

Page 1

Item ID: D350-636-011

Accept

Setup Start

Revision ID: F

Stop

Item Name: Skidtube LH

Start Date: 20/11/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

005 per ECN 09-702

DSI 9490 Rev. A

8
07/12/08

10/11/23

53865

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Start Date: 20/11/2009 Start Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end								
	2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.								
	3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.								
	4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"								
	5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	8-Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M112502								
	10-Grind welds flush as per Dwg D2750								

BE 09/11/24

AWM 9-11-24

BE 09/11/24

AWM 9-11-24

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____




QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	12- Scribe batch# inside per dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
									
HandFinish	Memo	0.00							
Hand Finishing									

- AWM 9-11-24

2) 8/11/24



2) 8/11/24



1

49/11/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

9-11-25

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI Q15
A/R ☐☐☐ Sikaflex-291 batch: 4112395 ☐☐☐
exp. date: 01/27/10

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M112507 BE 09/11/30

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places perside) as per
dwg D2750

11/11/25

AWM 9-11-30

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 09/11/30

12-Deburr holes

-AUM 9-11-30

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

27 Sorkeloz

Quality Control



180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 Sorkeloz

Quality Control



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				X1			
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148 Memo START TIME: 2:45 OVEN TEMPERATURE: 320° FINISH TIME: 2:15	0.00 0.00				BR09-12-2			
210 QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00				21 09/12/03			

W/O:		WORK ORDER CHANGES					
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Required Date: 02/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

HandFinishing

0.00

0.00

= 7 M 09/12/03

(XL)

/

Hand Finishing

Memo

1- Install inserts as per Dwg D2750

230



HandFinish

HandFinishing

0.00

0.00

= 7 M 09/12/03

(XL)

/

Hand Finishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

✓ SIKA FLEX 241
BATCH: N/A 12345
EXP DATE: 10/10✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: N/A 101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: N/A 101251

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	278 09/12/04						
250 Packaging Packaging	Pick Kit Memo	0.00 0.00				9/12/8 spf			
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00	278 09/12/08						

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-01/1								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH




Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC 		Manufactured	No			230	Each	854.0000	8.0000			
O-Ring, 205 Skidtube												
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				FP				27				
				51613				27				
				Main Warehouse								
				ST				827				
				52562				827				
D2744RevC 		Manufactured	No			110	Each	67.0000	1.0000			
Cap												
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				67				
				44892				1				
				47488				30				
				51922				36				
D2600-3-BENTRevD1 		Manufactured	No			110	Each	0.0000	1.0000			
Extrusion Bent												

x B 20 09/12/03

1 8E 09/11/24

252346 8E 09/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2743RevB		Manufactured	No			160	Each	355.0000	8.0000			
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Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 110

50281 50

51913 60

Main Warehouse

ST 245

44891 2

45555 57

48275 1

52310 185

8 86 09/11/30

D2739RevD		Manufactured	No			160	Each	1.0000	1.0000			
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350 I Beam

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1

47124 1

B 52900

1 19/11/25

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3490-3RevA

Manufactured

No

160

Each

65.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

45560

1

48276

31

51930

33

4 BE 02/11/30

D3490-1RevA

Manufactured

No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45338

2

47657

22

48277

48

51932

40

4 BE 09/11/30

W/O:		WORK ORDER CHANGES					
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Start Qty: 1.00

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Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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ALS4-1032-225		Purchased	No			220	Each	7,324.000	38.0000			
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Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7324

107441

16

110768

7308

D3492-041RevC		Manufactured	No			230	Each	140.0000	8.0000			
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Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

140

51584

140

D3793-3RevA		Manufactured	No			230	Each	23.0000	1.0000			
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Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

51592

12

51903

11

X38 M 09/12/03

X8 M 09/12/03

X1 M 09/12/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C35A  BOLT		Purchased	No			230	Each	144.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	144	
102180	1	
106896	1	
110105	48	
110847	94	

D3793-1RevA



Wearshoe

Manufactured No

230 Each 27.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
40551	1	
51597	16	
51906	10	

20/09/12/03

20/09/12/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3488-041RevB

Manufactured

No

230

Each

18.0000

1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47348

18

230

Each

28.0000

1.0000

D3794-3RevA

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

24

51598

12

51907

12

Main Warehouse

ST

4

46531

2

47440

1

47722

1

xl 09/12/03

xl 09/12/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A  BOLT		Purchased	No			230	Each	180.0000	4.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	178	
110105	4	
110155	14	
110665	1	
111605	50	
111649	50	
112720	9	
113121	50	

MS21083C8

Purchased

No



NUT

230

Each

72.0000

1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	72	
110584	5	
111424	2	
112492	15	
113149	50	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bir. Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3536-25RevA		Manufactured	No			230	Each	23.0000	1.0000			
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Gasket

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP10	18	
(51607)	18	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

x1 09/12/03

D3631-1RevA		Manufactured	No			230	Each	221.0000	8.0000			
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Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	221	
38139	6	
45353	16	
47437	1	
(52693)	198	

x8 09/12/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3791-1RevA

Manufactured

No

230

Each

19.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

51610

7

Main Warehouse

ST

12

51909

12

AN960C10L

Purchased

No

230

Each

2,658.000

38.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

2558

112116

548

112612

1010

112933

1000

Y1 M 09/12/03

X38 M 09/12/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53865



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2745RevB

Manufactured

No

230

Each

402.0000

8.0000



Bushing



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

88

34817

2

36230

8

37303

1

39587

2

40726

2

41114

2

42778

6

43754

2

44893

33

45556

1

48278

29

Main Warehouse

ST46

314

51537

70

51910

63

52311

181

y8 M 09/12/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			230	Each	1,118.000	34.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1118	
111424	8	
111707	69	
112314	1	
112641	440	
113121	300	
113149	300	

v3 11 09/12/03

D3537-1RevC



Wearpad

Manufactured No

230

Each

198.0000

3.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	196	
51678	91	
51679	105	

v3 11 09/12/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 20/11/2009


Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L  WASHER		Purchased	No			230	Each	260.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	260	
104093	2	
107520	4	
110139	29	
110372	10	
110584	100	
111424	115	

D3492-043RevC  Plug Assembly		Manufactured	No			230	Each	84.0000	8.0000			
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<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	84	
52309	84	

x1 H 09/12/03

x8 H 09/12/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A  BOLT		Purchased	No			230	Each	904.0000	4.0000			

Warehouse Loc Qty Loc Code
Location
Main Warehouse
ST 904

NAS1611-013

Purchased

No

111982

230

Each

138.0000

8.0000

O-RING

Warehouse Loc Qty Loc Code
Location
Main Warehouse
ST 138
 106513 11
 111424 20
 111758 107

x4 M 09/12/03

x8 M 09/12/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3535-25RevB

Manufactured

No

230

Each

24.0000

1.0000



Wearshoe

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

14

51663

1

51927

13

Main Warehouse

ST

10

52589

10

D3794-1RevA

Manufactured

No

230

Each

22.0000

1.0000



Gasket

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

12

51928

12

Main Warehouse

ST

10

46530

1

47212

2

51668

7

x1 09/12/03

x1 09/12/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21043-6		Purchased	No			230	Each	1,040.000	4.0000			
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NUT

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	1040	
	111424	40	
	112314	1000	

x4 9/12/03

S D3493-1RevA

Manufactured No



Washer

260	Each	69.0000	2.0000
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9/12/1 8/1

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	69	
	44902	2	
	47710	67	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21083C8

Purchased

No

260

Each

72.0000

2.0000



NUT



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

110584

5

111424

2

112492

15

113149

50

9/12/7 SI

AN8C21A

Purchased

No

260

Each

114.0000

2.0000



BOLT

2

9/12/8 SY

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

114

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

111684

4

112720

50

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53865

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item II/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960C816L

Purchased

No

260

Each

260.0000

2.0000



WASHER

[Handwritten signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

260

104093

2

107520

4

110139

29

110372

10

110584

100

111424

115

NAS1515H3L

Purchased

No

230

Each

266.0000

4.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

226

110450

2

111819

224

9/12/8 sf

2

9/12/8 sf

xa M or 12 103

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53865



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2741RevC

Manufactured

No

260

Each

53.0000

1.0000



Blade, 350 Skidtube

9/12/7 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

20770

0

45320

1

47113

12

51931

40

1 SP

D3532-1RevA

Manufactured

No

260

Each

93.0000

2.0000



Spacer

9/12/7 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

44904

2

52321

91

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 19

November 20, 2009 12:53:49 PM

Work Order ID: 53865



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L WASHER		Purchased	No			260	Each	81.0000	2.0000			

9/12/8 54

8 D3672.13
per ECN09.702

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	81	
107581	34	
108964	1	
111650	46	
D3672.13		
54363		
8		

2 sl

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

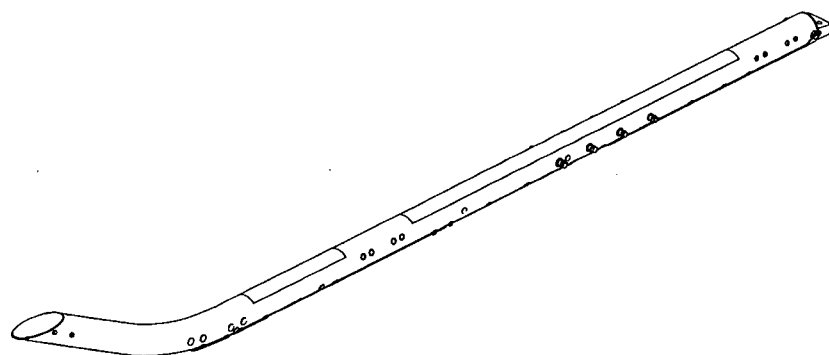
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

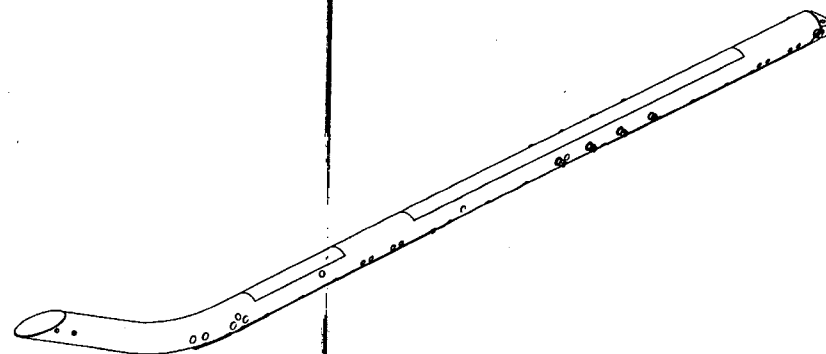
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53 EGS
BH 09-11-20

RELEASED
62 09 22 14

F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN6-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PA</u>	DART AEROSPACE USA, INC.	
DRAWN	<u>PA</u>	PORT HADLOCK, WA	
CHECKED	<u>PA</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>PA</u>	D2750	SHEET 1 OF 11
APPROVED	<u>PA</u>	TITLE	SCALE
DE APPR.	<u>PA</u>	350 SKIDTUBE ASSEMBLY	NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

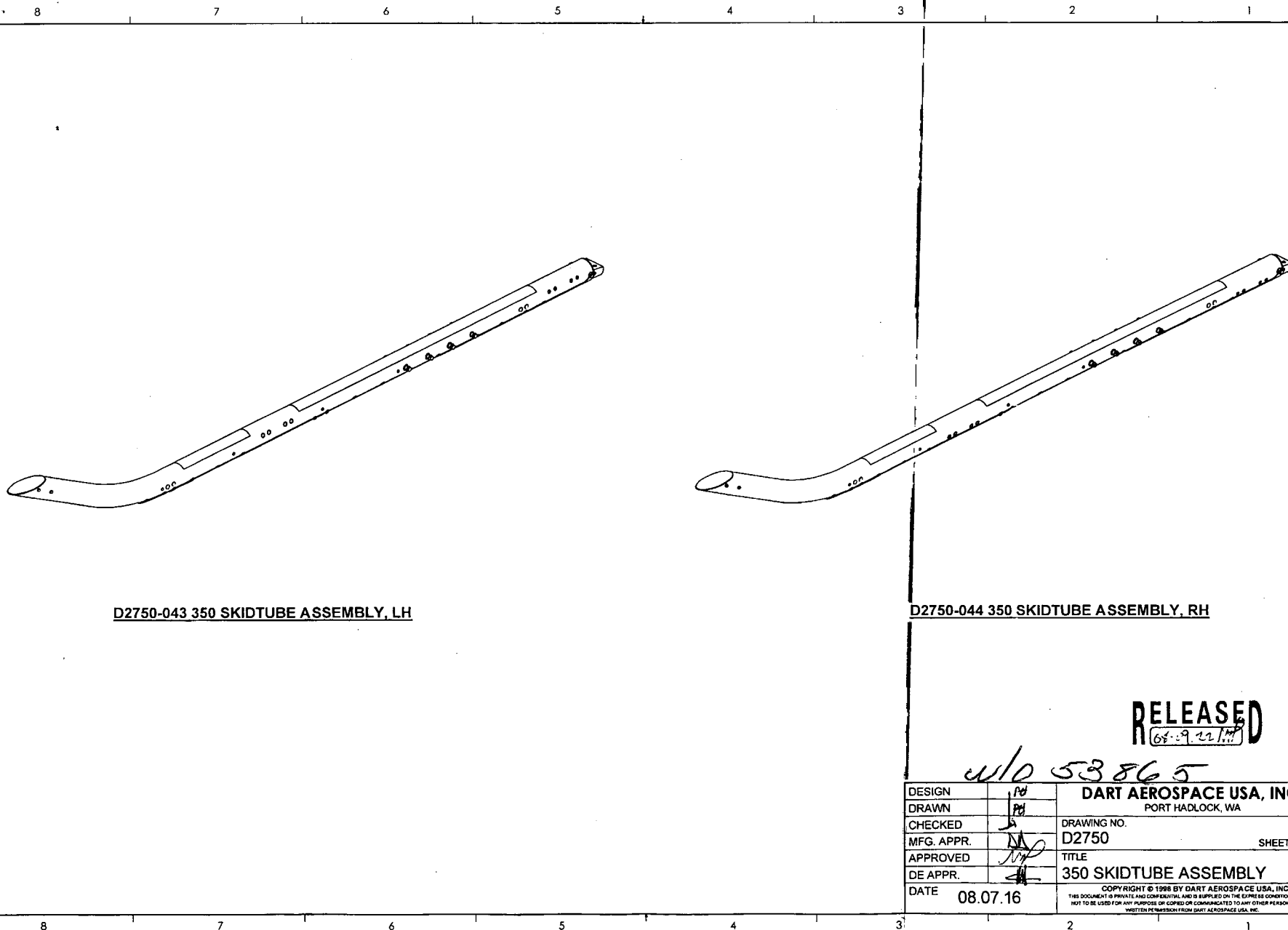


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-22-11

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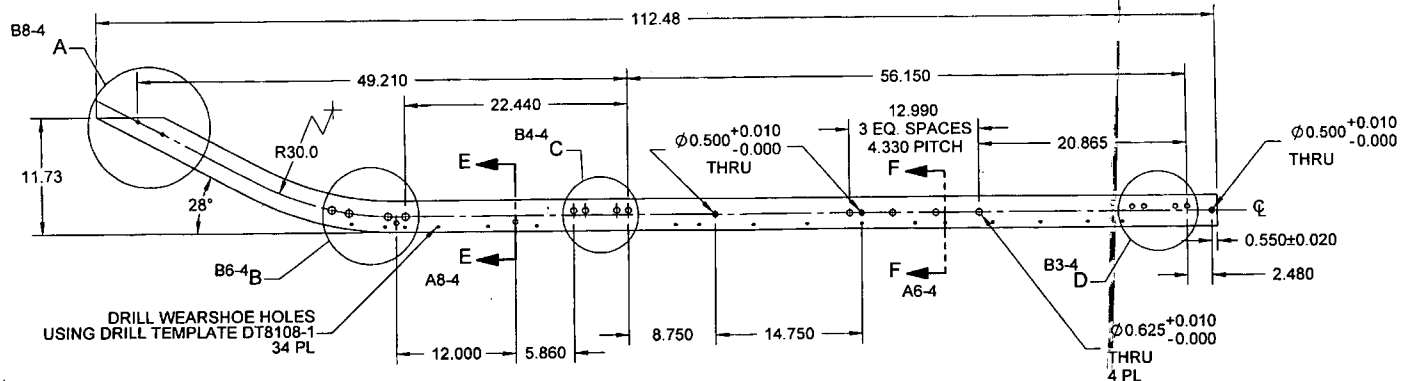
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

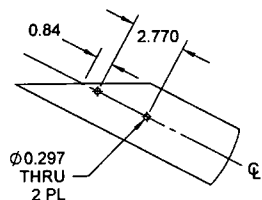
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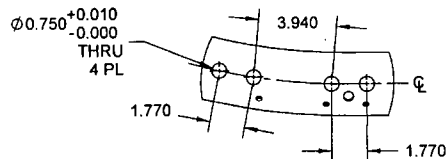
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CHECKED	<i>JA</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>NA</i>	D2750	SHEET 3 OF 11
APPROVED	<i>NA</i>	TITLE	SCALE
DE APPR.	<i>NA</i>	350 SKIDTUBE ASSEMBLY	NTS
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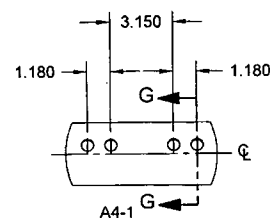
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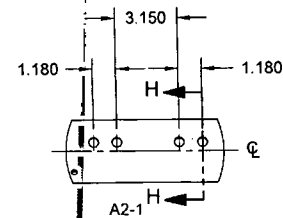
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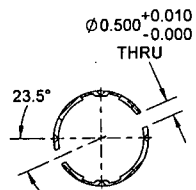
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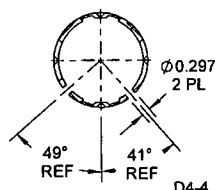
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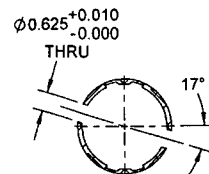
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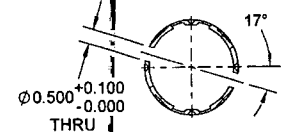
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



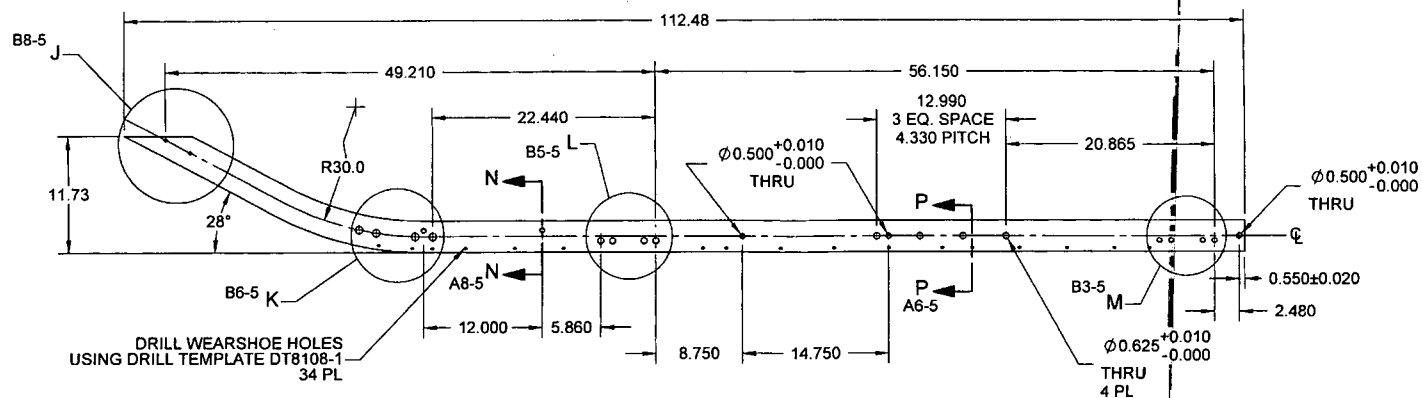
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DATE	08.07.16

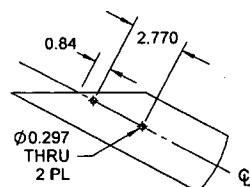
DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 4 OF 11
SCALE NTS	
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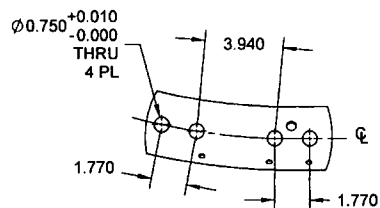
w/6 53865



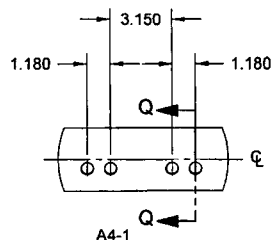
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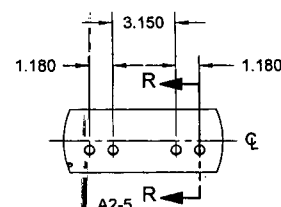
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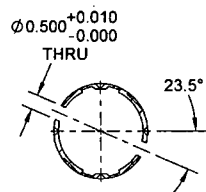
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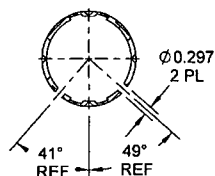
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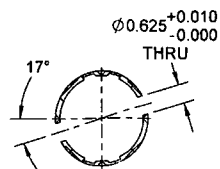
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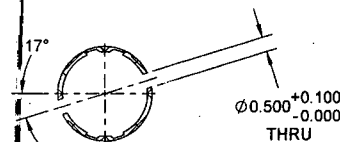
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



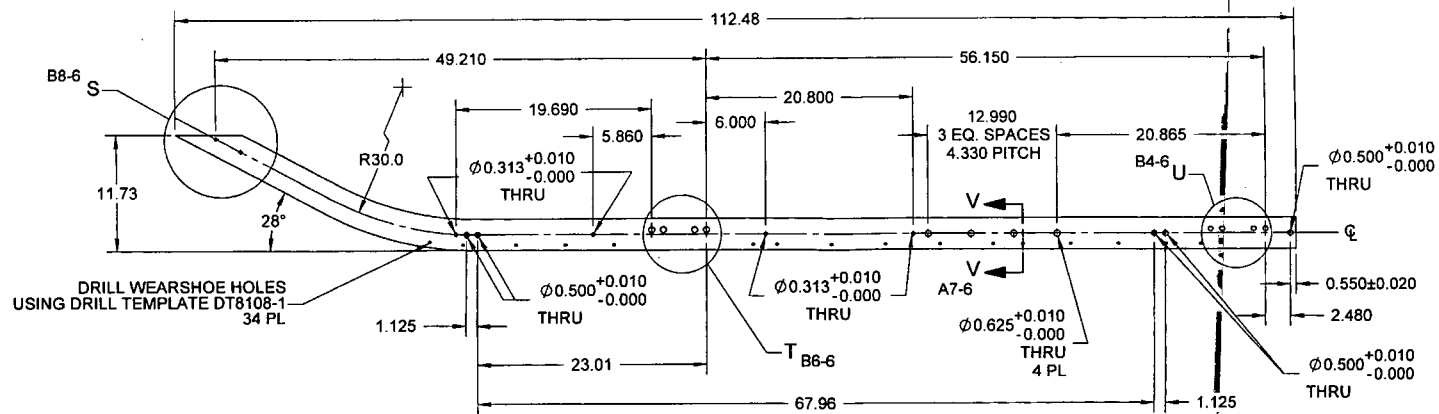
SECTION R-R
SCALE 3X, 4 PL

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DRAWN	PA		SHEET 5 OF 11
CHECKED			SCALE
MFG. APPR.			NTS
DE APPR.			

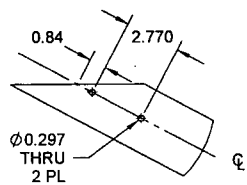
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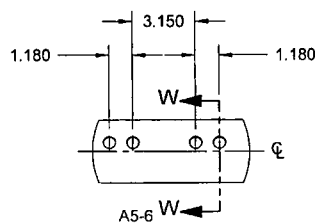
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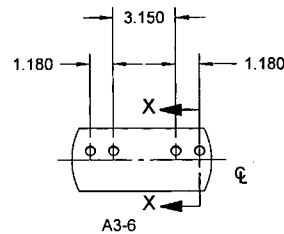
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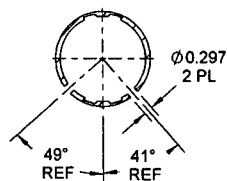
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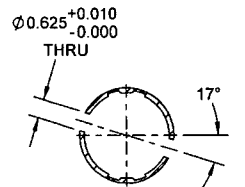
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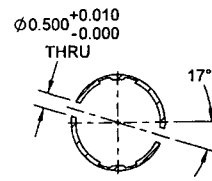
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SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

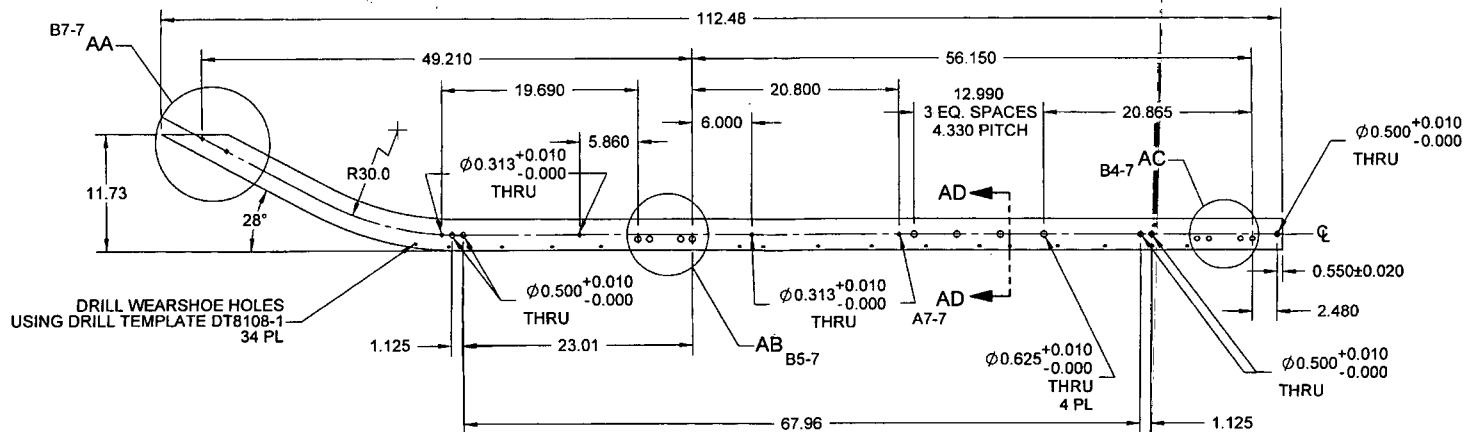


SECTION X-X
SCALE 3X, 4 PL

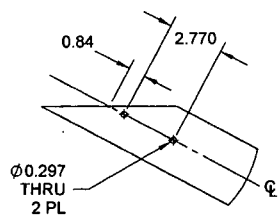
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W/O 53865

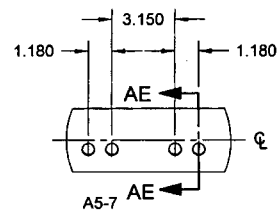
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CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
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DE APPR.			
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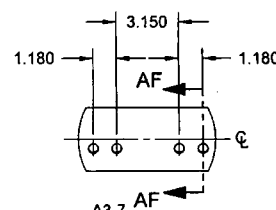
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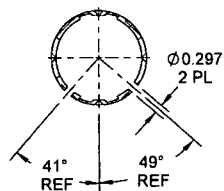
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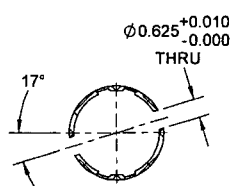
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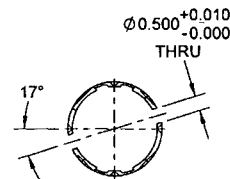
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

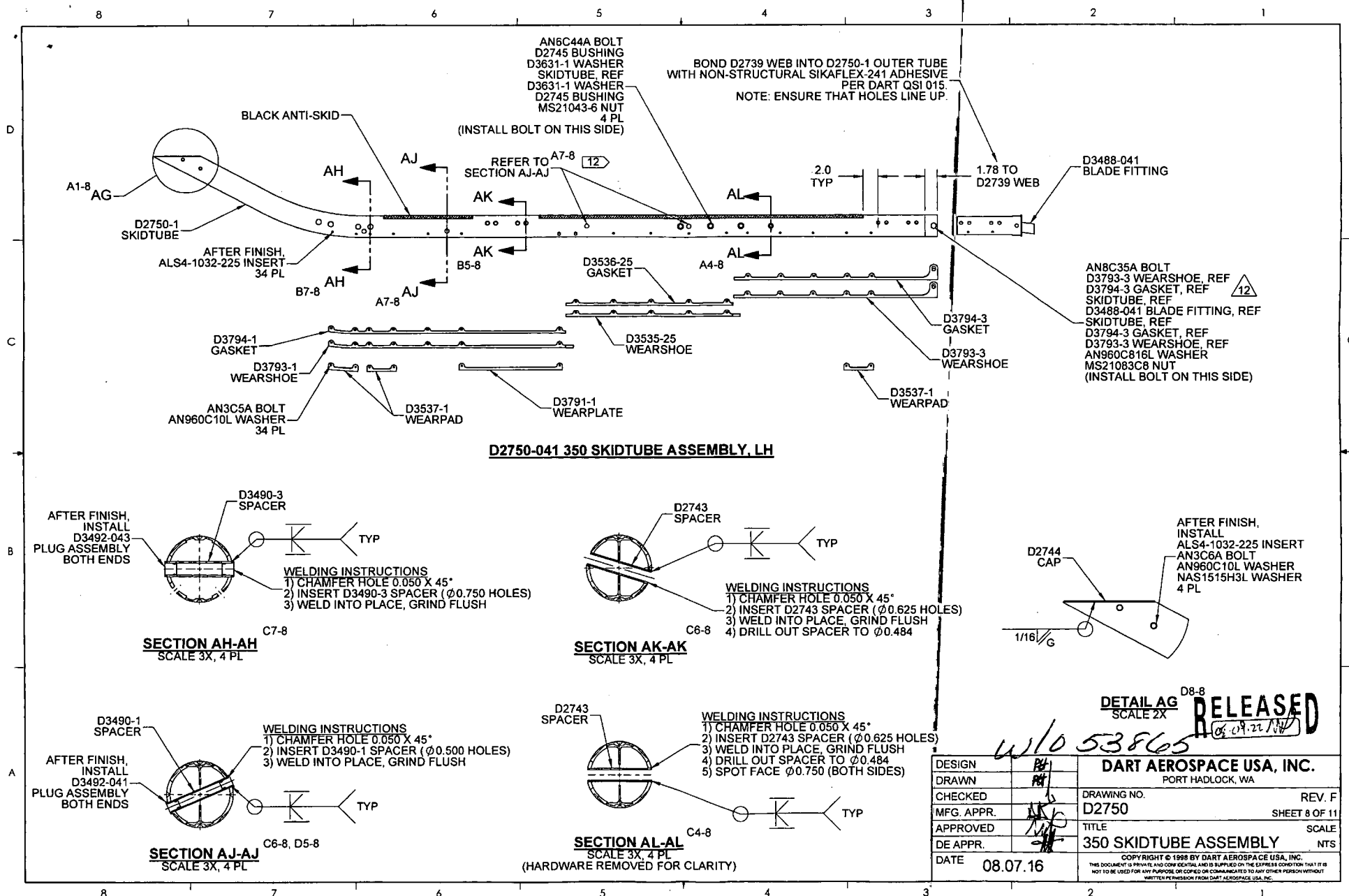


SECTION AF-AF
SCALE 3X, 4 PL

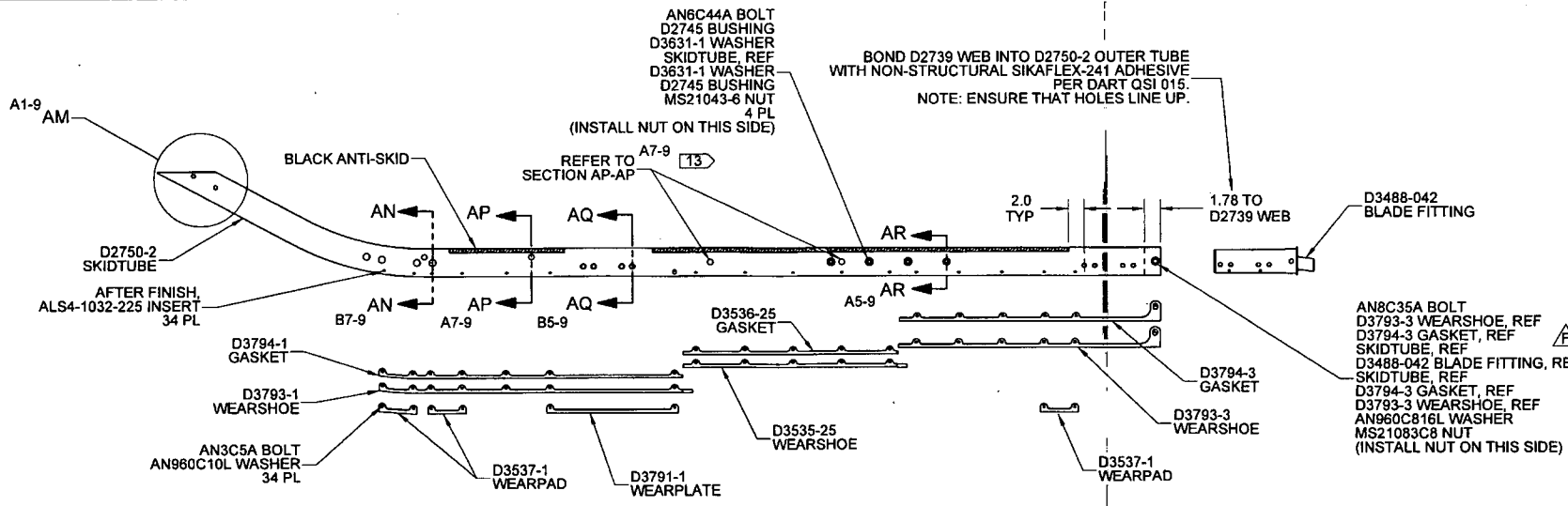
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06-04-22-10

W10 53865

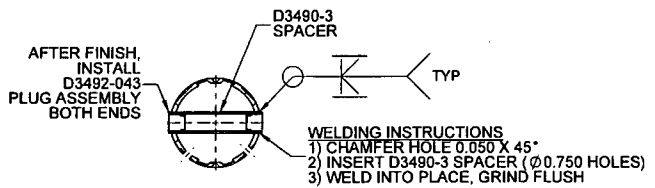
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DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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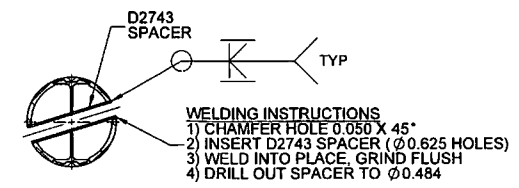
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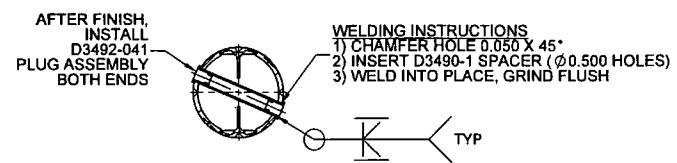
D2750-042 350 SKIDTUBE ASSEMBLY, RH



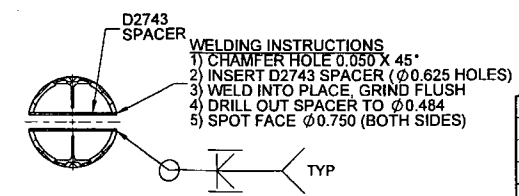
SECTION AN-AN
SCALE 3X, 4 PL



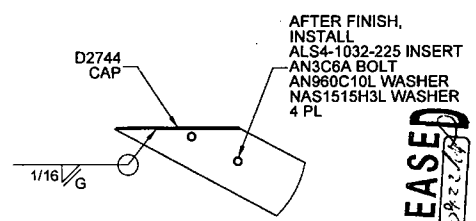
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

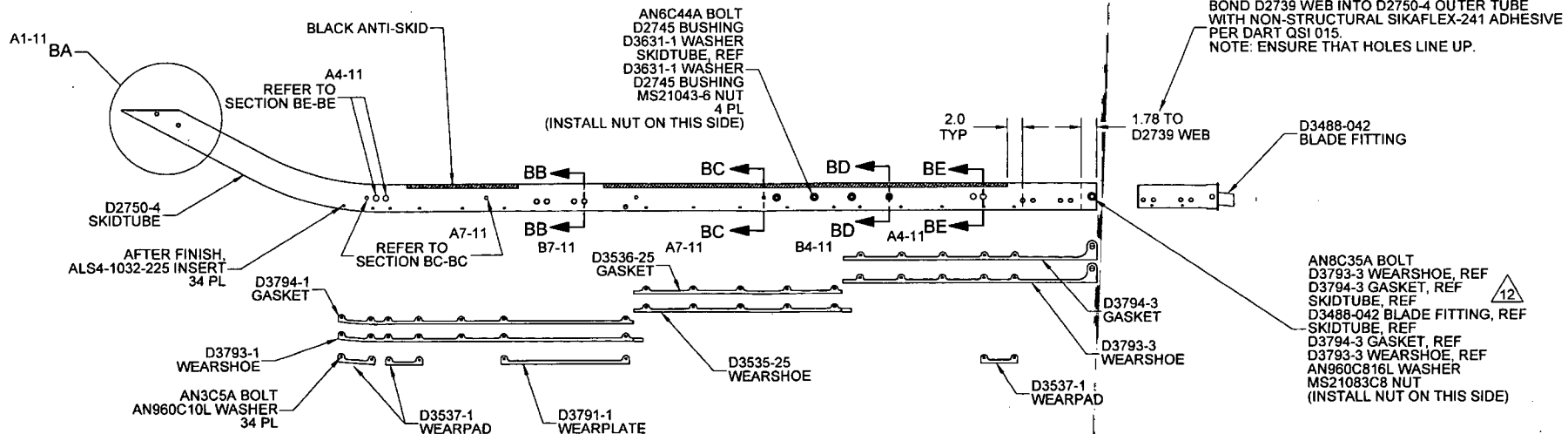


DETAIL AM
SCALE 2X

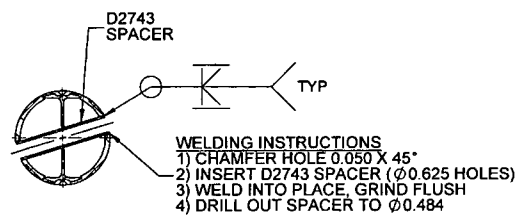
DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY SHEET 9 OF 11 SCALE NTS COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>
DRAWN	PH	
CHECKED	PH	
MFG. APPR.	PH	
APPROVED	PH	
DE APPR.	PH	REV. F
DATE	08.07.16	NTS

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 08-07-16

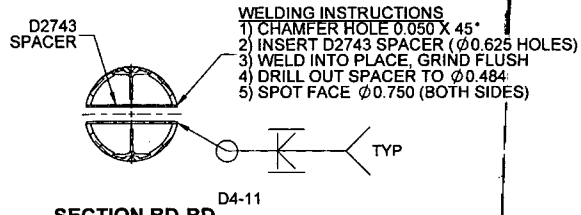
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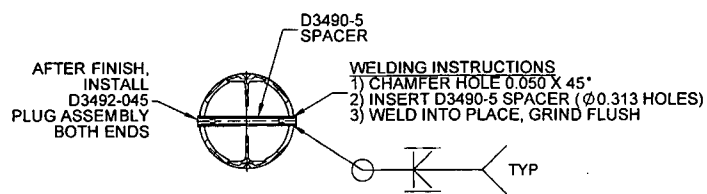
D2750-044 350 SKIDTUBE ASSEMBLY, RH



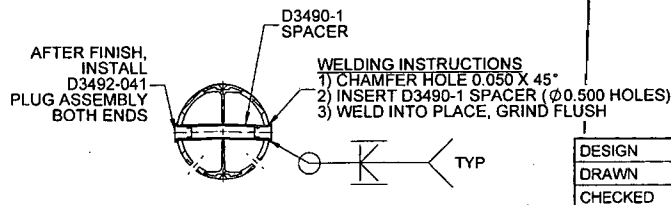
SECTION BB-BB
SCALE 3X, 4 PL



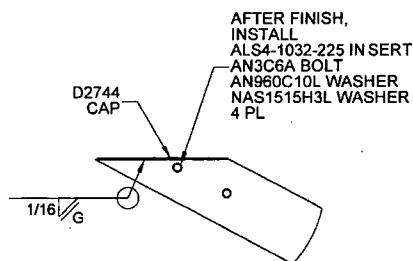
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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RELEASED

W/O 53865

NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B51620
Part number: 1350-636-Q12
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier David David

Date of Test Coupon

09/10/22

Welder Barclay Elliott

Date of Test Coupon

09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld